

Work Order ID 80924

Monday, March 05, 2012 11:30:11 AM

80924

Today please Page 1

Item ID: D4422-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 3/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-03-05 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4422

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

(4)

FF 12-03-05

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

5/2/13/05

(47)

120

Identify as per dwg & Stock Location: 139D

0.00

120

Packaging

Memo

0.00

Packaging

10/3/15 70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start ***NR1***

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Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/03/05
MF 12-03-05

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Picklist Print

Monday, March 05, 2012 11:30:10 AM

Page 1

Work Order ID: 80924

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 3/5/2012

Required Date: 3/6/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	100.8800		0.1016842			

Location

Loc Qty

Loc Code

MAT021

100.88

113608

53.69

118217

0.09

119513

10.8

120218

36.3

④ FF 12-03-05

~~0.1016842~~ 0.106315

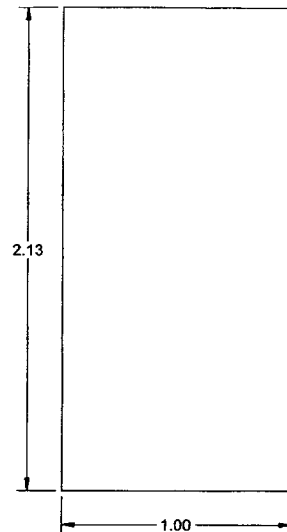
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D4422-X SHIM



P/N	T THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125

OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6S

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

RELEASED
2011-07-06

A	NEW ISSUE	DESCRIPTION	MB	11.06.22
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	11.06.22			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4422** REV. A
SHEET 1 OF 1

TITLE **SHIM** SCALE NTS

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